

5/03

DART AEROSPACE LTD	Work Order:	ZZ2074
Description: Bracket	Part Number:	D3207-5
Dwg: D3207 Rev. A	Qty:	30 Z5 Page 1 of 1

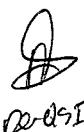
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 5. Dwg not required	JH	04.12.08	4
2	MV	Cut blank: 3.260" x 2.956" grain along 2.956" M15120 Material: 6061-T6 (QQ-A-250/11) 0.125" thick M11946 (M6061T6S.125) Identify for D3207-5 Batch: M15720	SP	04.12.10	30
3	MV	Machine D3207-5 as per Folio FA396 and Dwg D3207 Stack of 5 Identify as D3207-5	EP	05.01.20	25 P.D.
4	QC2	Inspect parts as they come off the CNC machine	EP	05.01.20	25
5	QC8	Second check	EP	05.01.20	25
6	GA	Deburr Stack	Z	05.01.24	25
7	GB	Form as per Dwg D3207	Z	05.01.25	25
8	QC5	Inspect work to Step 7	MH	05.01.25	25
9	FP	Chemical Conversion Coat as per QSI 005 4.1	MH	05.01.25	25
10	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	MH	05.01.26	25
11	QC3	Inspect Powder Coat	CL	05.01.27	25
12	ST	Identify and Stock	CL	05.01.27	25
13	AC	Cost / part <u>8.174</u>	SJ	05.01.28	25
14	DC	Close W/O <u>8.74</u> Inspect Level 21	JH	05.02.02	25

Rev	Date	Change	Revised By	Approved
A	04.06.09	New issue	KJ/RF	RF

RELEASED

RF 04.06.21

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/01/20	#3	first run scrap. one stack (five parts) �oved on table	 par-05142	destroy & replace	 05/01/31	 05/01/31	 par-05142	 05/01/31

Part No: D3207-5

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA:



Date: 05/01/21

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Job Costing Report

Dart Aerospace Ltd.
HawkesburyDec 06, 2004
11:09 am

Work Order No : 0022074
 Project Name : D3207-5
 Project For : WK503
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3207-5
 Description : Bracket
 Manufactured : Yes
 Amount Req'd : 4
 Amount Done : 0
 Start Date : 12-06-04
 Est Finish Date : 01-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss)	0.00	0.00

DART AEROSPACE LTD	Work Order:	22074
Description: BRACKET	Part Number:	D3207-5
Inspection Dwg: D3207 Rev: 4		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

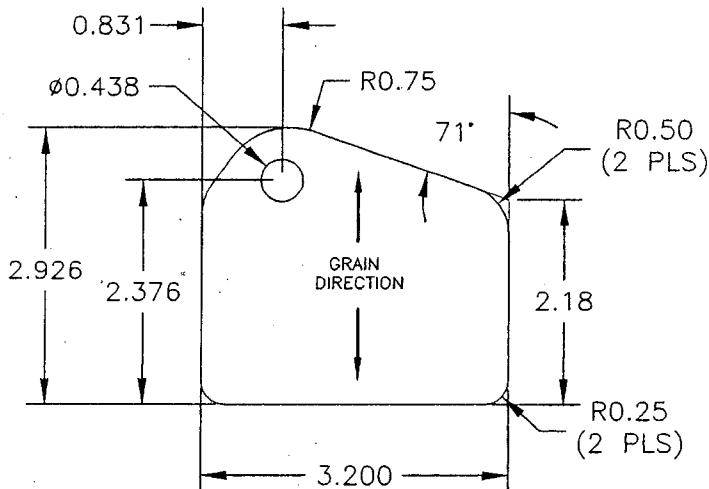
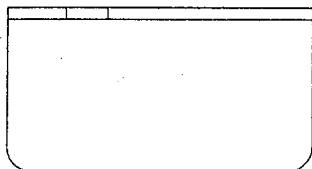
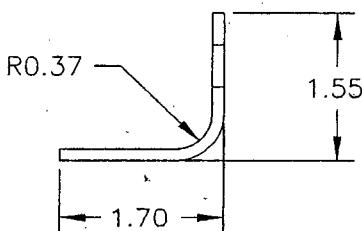
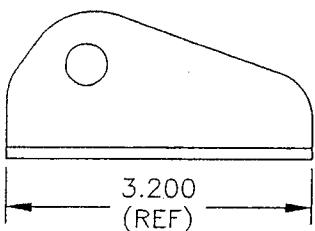
Measured by:	Er	Audited by:	gml	Prototype Approval:	N/A
Date:	05/01/20	Date:	05/01/20	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

UNCONTROLLED COPY

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D3207	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2

RELEASED
04.04.05D3207-5 FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22074

D3207-5 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES